

Ship ASAP

Work Order ID 56550



Page 1

March 7, 2010 11:36:03 AM

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Kit, 206 A/B Float Step

Start Date: 3/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/03/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI9500-011  
CHG001

0.00

8/10/03/02

HJ for BG 10/03/02

110

Pick Kit

0.00



Packaging

Memo

Packaging

0.00

P 11/3/02 (2)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/10/03/02

(12)

# Work Order ID 56550

March 1, 2010 11:36:03 AM



Page 2

Item ID: DSI 9500-011

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI9500-011

Location: \_\_\_\_\_

PPP rev: \_\_\_\_\_

*Draft*

10-3-2

50

*[Signature]*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/02 *[Signature]*

MF

10-3-1

# Picklist Print

March 1, 2010 11:36:00 AM

Work Order ID: 56550

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Kit, 206 A/B Float Step

Start Date: 3/01/10

Required Date: 3/03/10

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2731-7/ <i>28</i> 		Manufactured	No			110	Each	77.0000	4.0000			
<i>82</i> Mounting Lug												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

77

34125

1

41597

36

52330

40

D2732-030 *8x @ 3000 - measure out 1/2*

Manufactured No

110

Each

0.0000

16.0000

Rubber Cushion

D3394-043 *28*

Manufactured No

110

Each

114.0000

4.0000

*5* Lug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69

44521

19

45365

50

Main Warehouse

ST475

45

52331

45

D4064-041 *18*

Manufactured No

110

Each

0.0000

2.0000

Lug ass'y

# Picklist Print

March 1, 2010 11:36:00 AM

Page 2

Work Order ID: 56550

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Start Date: 3/01/10

Required Date: 3/03/10

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4C13A 44

Purchased

No

110

Each

8.0000

8.0000



BOLT

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

8

113359

8

AN4C14A 44

Purchased

No

110

Each

115.0000

8.0000



Bolt

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

115

107087

1

111902

114

AN4C15A 44

Purchased

No

110

Each

62.0000

8.0000



Bolt

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

62

113595

28

113603

34

March 1, 2010 11:36:00 AM

Shop Packet Print

Page 2

# Picklist Print

March 1, 2010 11:36:01 AM

Work Order ID: 56550



Parent Item: DSI 9500-011



Parent Item Name: Lug Upgrade Kit, 206 A/B Float Step


Start Date: 3/01/10

Required Date: 3/03/10

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Start Qty: 2.00

Required Qty: 2.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C416 <i>ILX</i>  washer		Purchased	No			110	Each	511.0000	32.0000	✓		<i>60</i>

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    511

100993    511

AN960C416L <i>8Y</i>  WASHER		Purchased	No			110	Each	1,378.000	16.0000	✓		<i>M/60993</i>
--	--	-----------	----	--	--	-----	------	-----------	---------	---	--	----------------

Warehouse                      Loc Qty                      Loc Code  
Location

OFFSHORE

FG    44

104925    44

Main Warehouse

ST    1334

111916    2

112612    432

112794    500

112828    400

*M/12612*

*P/14312*

# Picklist Print

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Required Date: 3/03/10

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1515H4L 214

Purchased

No

110

Each

340.0000

48.0000



WASHER

## Warehouse

## Loc Qty

## Loc Code

### Location

OFFSHORE

FG

40

103691

40

Main Warehouse

ST

300

105857

2

111359

22

112492

276

MS21043-4 22X

Purchased

No

110

Each

448.0000

24.0000



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

OFFSHORE

FG

40

104603

40

Main Warehouse

ST

408

112314

100

112492

11

113064

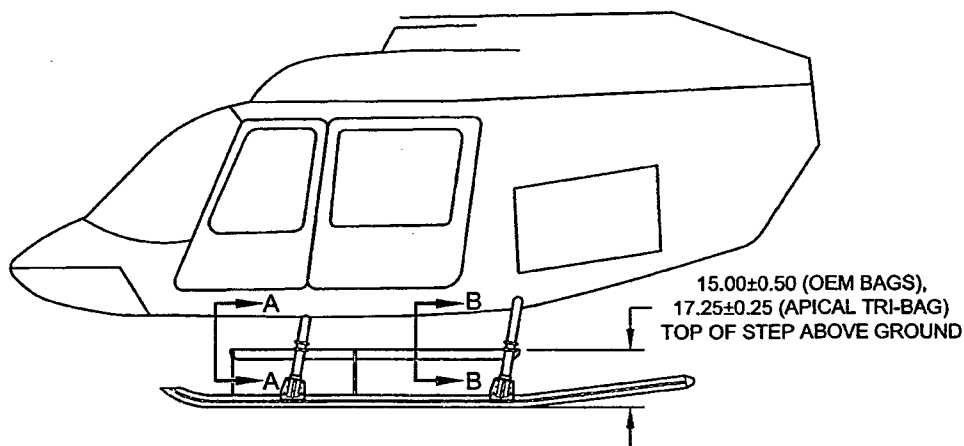
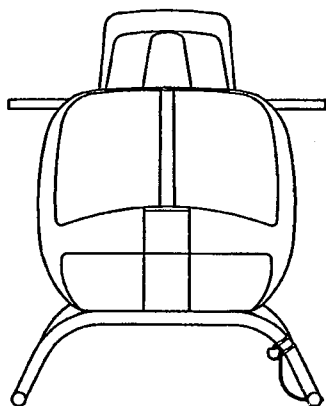
297

March 1, 2010 11:36:01 AM

Shop Packet Print

THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

QTY -011	Part Number	Description
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
2	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960G416	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

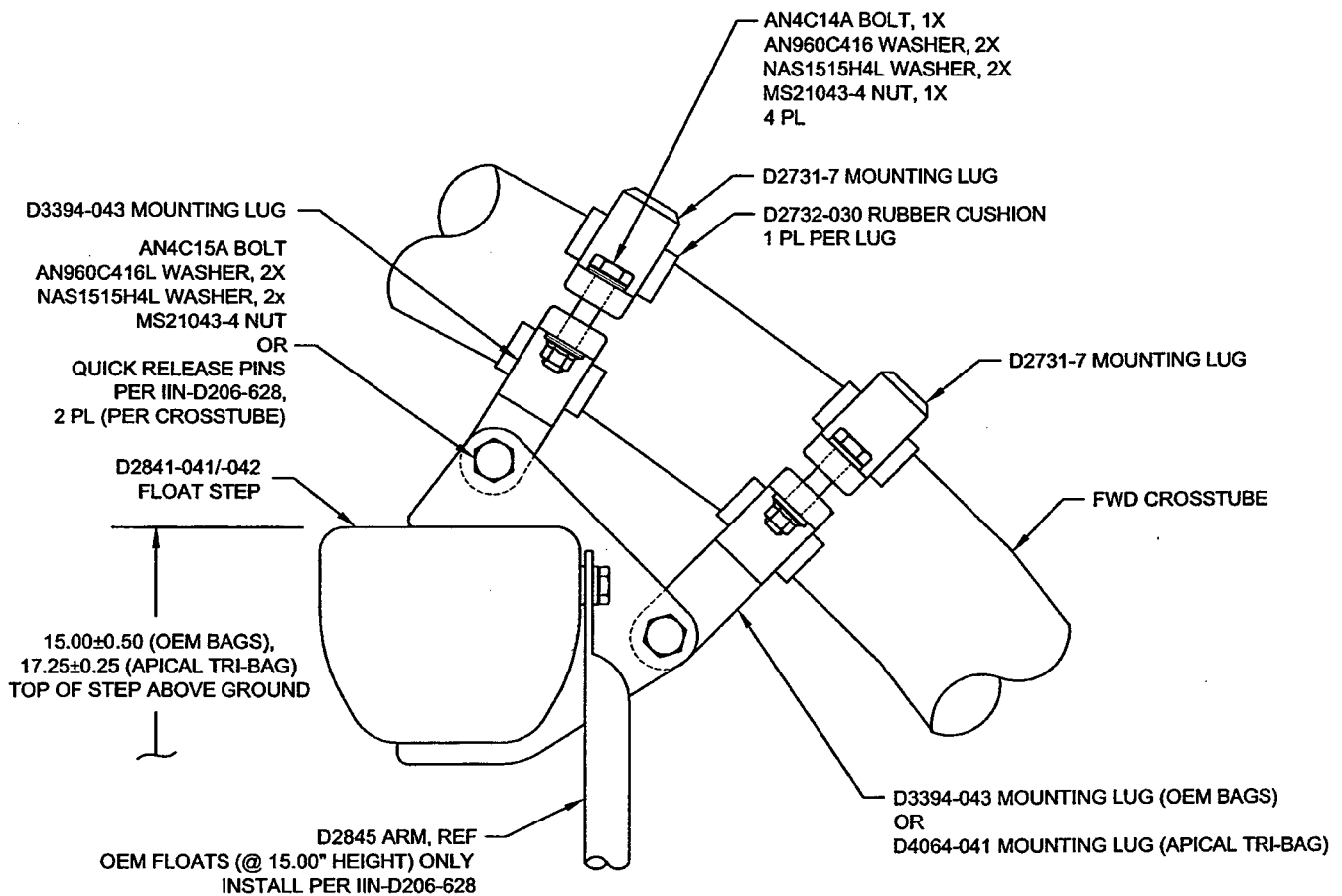


**FIGURE 1**

D206-628-013 (SHOWN) / -014 (OPPOSITE)  
206 A/B FLOAT STEP INSTALLATION

56550

DESIGN	99	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA
DRAWN	99	
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9500 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		MOUNTING LUG CHANGE NTS
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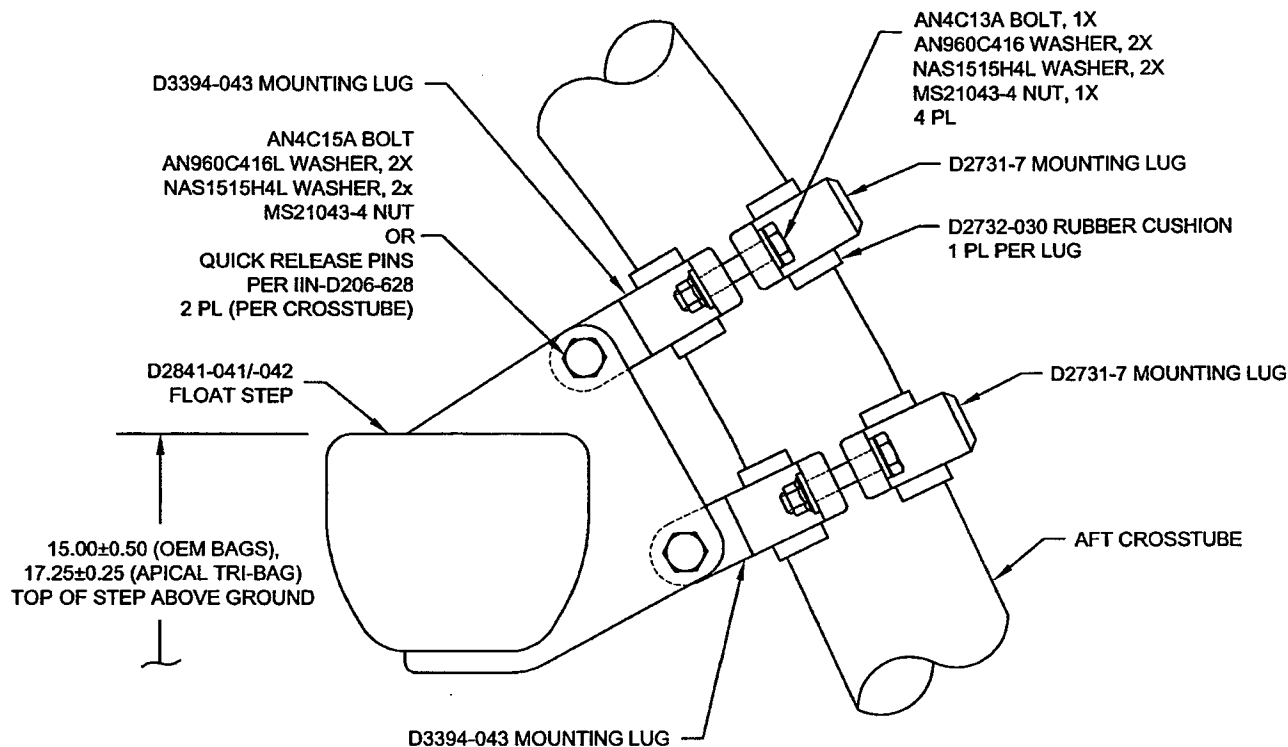


**SECTION A-A**  
FWD CROSSTUBE CLAMPING DETAIL

56550

DESIGN	GP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	GP	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 3 OF 4
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	MOUNTING LUG CHANGE	NTS
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**SECTION B-B**  
AFT CROSSTUBE CLAMPING DETAIL

*\* 56550*

DESIGN	<i>99</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>99</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9500	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG CHANGE	NTS
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

**PURPOSE:**

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

**CHANGE:**

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG
4	4					D3394-043	MOUNTING LUG
1	1					D4064-041	MOUNTING LUG (NEW)
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER

\* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

52550

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	9P	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	9P		
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 1 OF 4
APPROVED	H	TITLE	SCALE
DE APPR.	H	MOUNTING LUG CHANGE	NTS
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